

Work Order ID 149956

August 16, 2016 10:08:41 AM

149956

Page 1

Item ID: D5283-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Basket Clamp Assembly
Start Date: 8/16/2016 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 8/23/2016 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: SA Date: AUG 15 2016 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5283	A								

100

0.00

100

Bandsaw

Memo

0.00

Jeaspa Bandsaw

CUT TO 5.5" LONG

DAS

32

9-89

16-08-10

105

0.00

105

Purchasing

Memo

0.00

Purchasing

Issue p.o.:

Possible supplier: Metec

Machine, Alodine and powder Coat as per Dwg ***Note mask bore prior to powder coat***

C of C is required

AUG 17 2016

DAS

13

9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Work Order ID 149956

August 16, 2016 9:24:17 AM

149956

Page 3

Item ID: D5283-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Basket Clamp Assembly
Start Date: 8/16/2016 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 8/23/2016 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	QC5- Inspect part completeness to step on W/O	0.00							
200									
QC	Memo	0.00							
Quality Control									DAS 38 9-89 SEP 15 2016
210	Identify as per dwg & Stock Location: <u>St 523</u>	0.00							
210									
Packaging	Memo	0.00							DAS 6 9-89 SEP 16 2016
Packaging									P.T.O.
220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.00							DAS 21 9-89 SEP 16 2016
Quality Control									DAS 21 9-89 SEP 16 2016

DQA:

Date:

JAN 4 2017



QA Closed:

Date:

OCT 18 2016

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Work Order: <u>149956</u>		DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. <u>DS283-041</u>		Rework ☒		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
NCR No. <u>16-6104</u>		Scrap ☐		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
		Use-as-is ☐		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☒		
		Suspected Unapproved ☐		Large Fab ☐	Composite ☐	Supplier ☐			
Date: <u>16-09-15</u>		Step #: <u>210</u>		QTY Effective: <u>10</u>			MRB (QSI042) Approval		
Description Work Order Deviation		Disposition			DAS 9 9-89 16-09-15				
port found in store <u>finish but not (painted) complete</u> <u>Finished</u> R.C. poor info.		- remove and kept bearing F.F. - alodine and powder coat as per drawing. DS283/BEB - re install bearing. press fit and stake at 4 place. (Different location than first time) M135418 START: 7:50 O.U.T: 320° FINISH: 8:20 10 of 16-09-			Completed By 16/09/16 DAS 36 Lead Hand / Supervisor Approval Verification 38 9-89 SEP 16 2016				
QC / QA Coordinator Approval		DAS 9 9-89 16-09-23							
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	☒ Poor Information	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	☒ Instructions Incomplete/Unclear	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

Picklist Print

August 16, 2016 9:24:23 AM

Page 1

Work Order ID: 149956

149956

Parent Item: D5283-041

D5283-041

Parent Item Name: Basket Clamp Assembly

Start Date: 8/16/2016

Required Date: 8/23/2016

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 15.07.06 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2611		Manufactured	No				Each	20.0000		10			
D2611									**				
Bearing													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST008A				20					
				134776				20					
D5283-1P		Purchased	No				Each	0.0000		10			
D5283-1P									**				
Basket Clamp													
M6061T6B30000X01.5		Purchased	No				f	12.8270		4.842105			
00													
M6061T6B30000X01 500									**				
6061-T6 Bar 3.00 x 1.50													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT004				12.827					
				m133699				0.827					
				m134984				12					

FF Sep. 16.16

10

DAS

6

9-89

AUG 25 2016

DAS

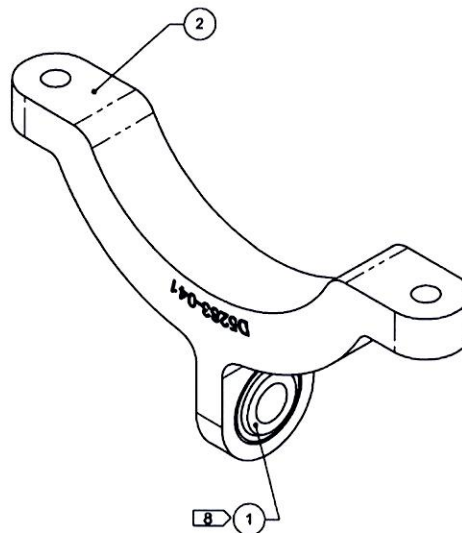
32

9-89

16-08-16

4.6771

ITEM	QTY	P/N	DESCRIPTION
	X	D5283-041	BASKET CLAMP ASSY
1	1	D2611	BEARING
2	1	D5283-1	BASKET CLAMP



D5283-041 BASKET CLAMP ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.28 lbs
- 8) PRESS FIT D2611 BEARING AND STAKE 4 PLACES PER SIDE

AUG 15 2016

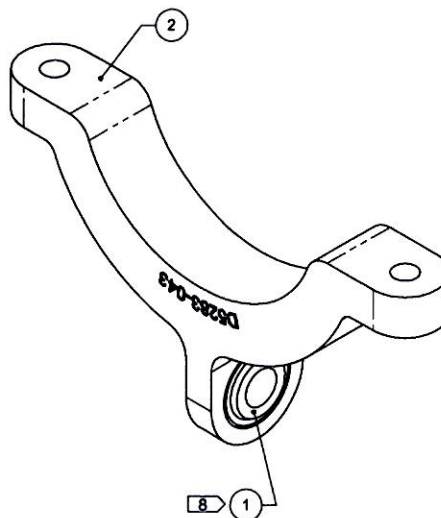
54
149956

RELEASED
2015-07-20
ERN 15-607

A	NEW ISSUE	DB	15.06.30
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	JLM	D5283	SHEET 1 OF 6
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	BASKET CLAMP ASSY	NTS
DATE	15.06.30	COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED

ITEM	QTY	P/N	DESCRIPTION
	X	D5283-043	BASKET CLAMP ASSY
1	1	D2611	BEARING
2	1	D5283-3	BASKET CLAMP



D5283-043 BASKET CLAMP ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.28 lbs
- 8) PRESS FIT D2611 BEARING AND STAKE 4 PLACES PER SIDE

APPROVED	DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	DB		
	CHECKED	AP	DRAWING NO.	REV. A
	MFG. APPR.	JLM	D5283	SHEET 2 OF 6
	APPROVED	WM	TITLE	SCALE
	DE APPR.	DS	BASKET CLAMP ASSY	NTS
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2015-07-20

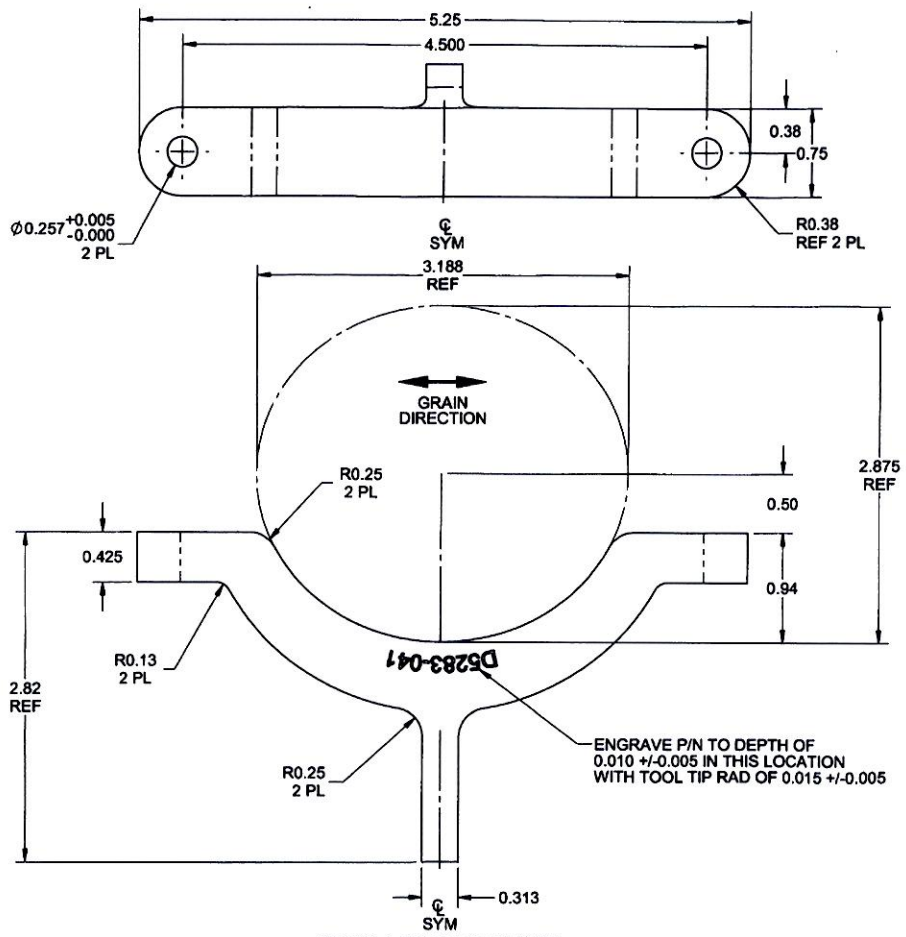
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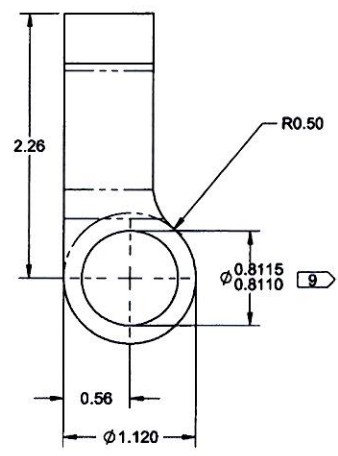
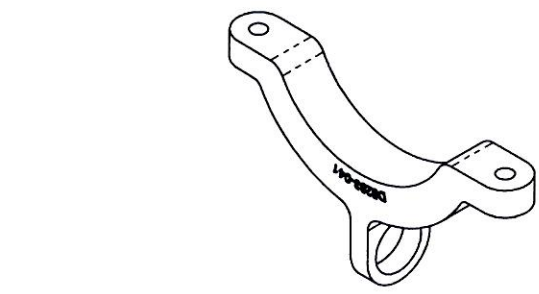
C

B

A



D5283-1 BASKET CLAMP

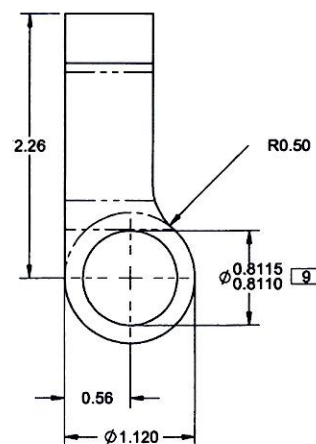
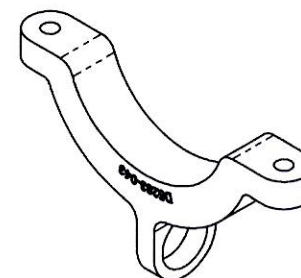


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2015-07-20

- NOTES:**
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221 PER DART SPEC M6061T6B
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3 PER DART SPEC M6061T6B
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY AS D5283-041 PER QSI 044 6.3
 - 7) WEIGHT: 0.24 lbs
 - 8) NON DIMENSIONED FEATURES-REFER TO 3D CAD FILE D5283-1.Rev A.STEP
 - 9) MASK BEARING BORE PRIOR TO POWDER COAT

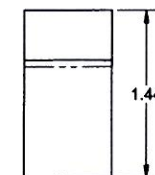
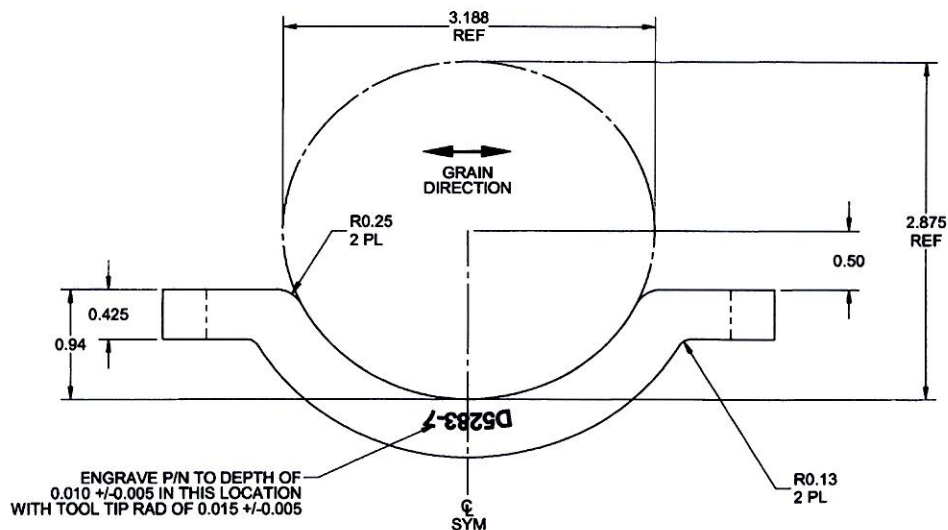
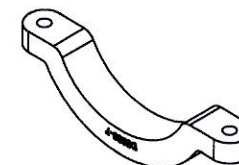
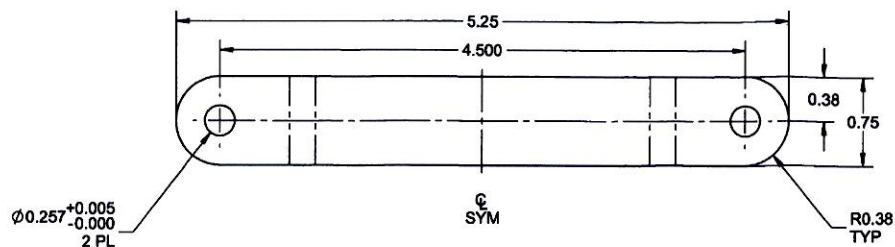
APPROVED	DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	DB		
	CHECKED	AP	DRAWING NO.	REV. A
	MFG. APPR.	JLM	D5283	SHEET 3 OF 6
	APPROVED	WM	TITLE	SCALE
	DE APPR.	DS	BASKET CLAMP ASSY	NTS
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8 7 6 5 4 3 2 1



RELEASE
2015-07-20

APPROVED	DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D5283 TITLE BASKET CLAMP ASSY	REV. A
	DRAWN	DB		SHEET 4 OF 4
	CHECKED	AP		SCALE
	MFG. APPR.	JLM		NTS
	APPROVED	WM		
	DE APPR.	DS		
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ENGRAVE P/N TO DEPTH OF
0.010 $\pm$ 0.005 IN THIS LOCATION
WITH TOOL TIP RAD OF 0.015 $\pm$ 0.005

D5283-7 BASKET CLAMP

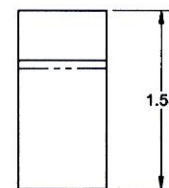
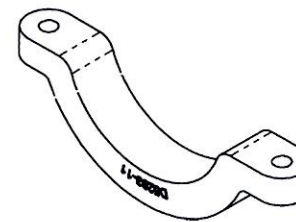
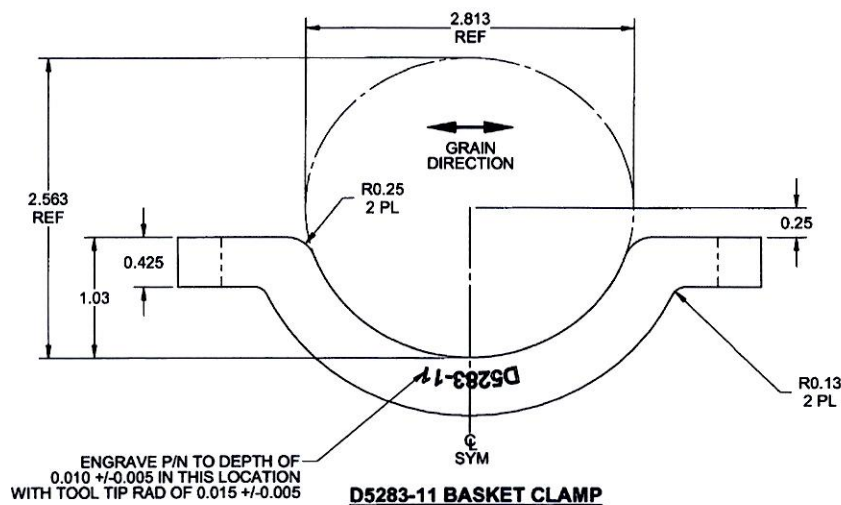
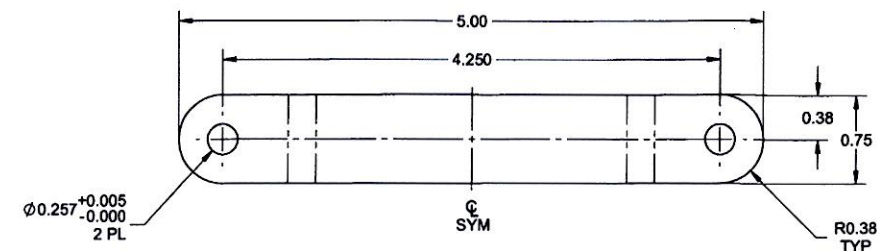
NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221 PER DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AS D5283-7 PER QSI 044 6.3
- 7) WEIGHT: 0.20 lbs
- 8) NON DIMENSIONED FEATURES-REFER TO 3D CAD FILE D5283-7.Rev A.STEP

RELEASED
2015-07-20

DESIGN	DB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	JLM	D5283	SHEET 5 OF 8
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	BASKET CLAMP ASSY	NTS
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- NOTES:**
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 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY AS D5283-11 PER QSI 044 6.3
 - 7) WEIGHT: 0.20 lbs
 - 8) NON DIMENSIONED FEATURES-REFER TO 3D CAD FILE D5283-11.Rev A.STEP

D5283-11 BASKET CLAMP

RELEASED
2015-07-20

APPROVED	DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	DB		
	CHECKED	AP	DRAWING NO.	REV. A
	MFG. APPR.	JLM	D5283	SHEET 6 OF 6
	APPROVED	WM	TITLE	SCALE
	DE APPR.	DS	BASKET CLAMP ASSY	NTS
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20 Terry Fox Drive
 Vankeek Hill, Ontario K0B 1R0, Canada
 Tel: (613) 678-3957
 Fax: (613) 678-3956

Delivery Slip No.: 21355
 Date: Aug 24, 2016
 Page: 1

Sold to:		Ship to:	
Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7		Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	
Order No.: 33342		Sold By: VanDenYssel, David	
Shipped By: your truck		Ship Date: Aug 24, 2016	

Description		Unit	Ordered quantity	Shipped quantity	Backorder quantity
D5283-1 Basket Clamp, no finishing		Each	10	10	1
Set-up fee is applied to quantities below 25					
D5283-3 Basket Clamp, no finishing		Each	10	9	1
Set-up fee is applied to quantities below 25					
One of these parts is questionable, please check and let us know if you except it. (marked in a bag) One piece was scrapped					
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.					
Received by _____		Thank you for your order!			

25/8/16
 30



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0
Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
10	D5283-1	Lug ✓	33342
9	D5283-3	Lug ✓	33342

MATERIAL: supplied by DART B127892

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Jan Norris

Vankleek Hill, August 24, 2016



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO33342**

Purchase Order Date 8/17/2016

PO Print Date 8/17/2016

Page Number 1 of 2

Order From :

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, ON K0B 1R0
CA

VC-MET003

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED

AUG 18 2016

Contact Name

Vendor Phone 613 678 3957

Ship To Contact

Ship To Phone

Ship Via: Dart Truck

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms Net 10

Currency CAD

FOB Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D5283-1P AS PER DWG D5283 REV. A B149956 MAT'L CUT TO SIZE: 6061-T6 BAR 3" X 1.5" X 10 PCS M133699 SET UP FEE INCLUDED IN PRICE OF CLAMPS	Basket Clamp	9/2/2016 Yes 9/2/2016	FN	10.00 Each	\$30.75	\$307.50

2	D5283-3P AS PER DWG D5283 REV. A B149955 MAT'L CUT TO SIZE: 6061-T6 BAR 3" X 1.5" X 10 PCS M133699 SET UP FEE INCLUDED IN PRICE OF CLAMPS	Basket Clamp	9/2/2016 Yes 9/2/2016	FN	10.00 Each	\$28.75	\$287.50
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Line Total: \$307.50

Note:

8/17/2016